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D4634-141
Job Sheet 183475



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4634 REV G SHEET 7 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/16/18	10/16/18	0.00	0.00	Start Up Small Fab		Smf
100	HandThermo	1 pcs	10/16/18	10/16/18	0.00	1.65	HandFinish4		Smf
110	Small Fab	1 pcs	10/16/18	10/16/18	0.00	1.47	Small Fab		Smf
120	QC	1 pcs	10/16/18	10/16/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	10/16/18	10/16/18	0.00	0.00	Packaging3	PEG	OCT 16 2018
140	QC21-SA	1 Ea	10/16/18	10/16/18	0.00	0.00	QC21		OCT 16 2018

Part Op 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Descriptions: Batch: P003861 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # m138691 Expiry Date 24 May 2020 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4634-1	Fwd, Center Ceiling Panel	1 Ea (1 ea)	90-Start up Operation	5117967
D4636-5	Bracket	1 Ea (1 ea)	90-Start up Operation	5004455
D4647-5	Doubler	1 Ea (1 ea)	90-Start up Operation	5003302
D4664-5	Spacer	6 Ea (6 ea)	90-Start up Operation	5033992
D4712-1	Bracket	1 Ea (1 ea)	90-Start up Operation	5008996
D4732-15	Label	1 Ea (1 ea)	90-Start up Operation	5104125
D4732-19	Label	1 Ea (1 ea)	90-Start up Operation	5008993
D5021-1	Foam, Center Panel, Fwd	1 Ea (1 ea)	90-Start up Operation	5033999
MPNY-750S-9-C	Mounting Pad	7 pcs (7 ea)	90-Start up Operation	Fm130423-1
MS20426AD3-4	Rivet	4 Ea (4 ea)	90-Start up Operation	Fm136444-2
MS20426AD4-6	Rivet	2 Ea (2 ea)	90-Start up Operation	5093088
MS21059L08	Nut	2 Ea (2 ea)	90-Start up Operation	5019317

CCR 26465-3-03

X 4

5057551

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4634-1	1	3	0
	D4636-5	1	48	0
	D4647-5	1	2	0
	D4664-5	6	27	0
	D4712-1	1	8	0
	D4732-15	1	13	0
	D4732-19	1	16	0
	D5021-1	1	1	0
	MPNY-750S-9-C	7	133	0
	MS20426AD3-4	4	4,580	0
	MS20426AD4-6	2	1,936	0
	MS21059L08	2	151	0

Part Specifications

Specifications could not be found.

Plex 10/15/18 10:36 AM dart.leroux.jason



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Container No: S118292



Part: D4634-141

Job No: 183475

Serial No/Batch: S118292

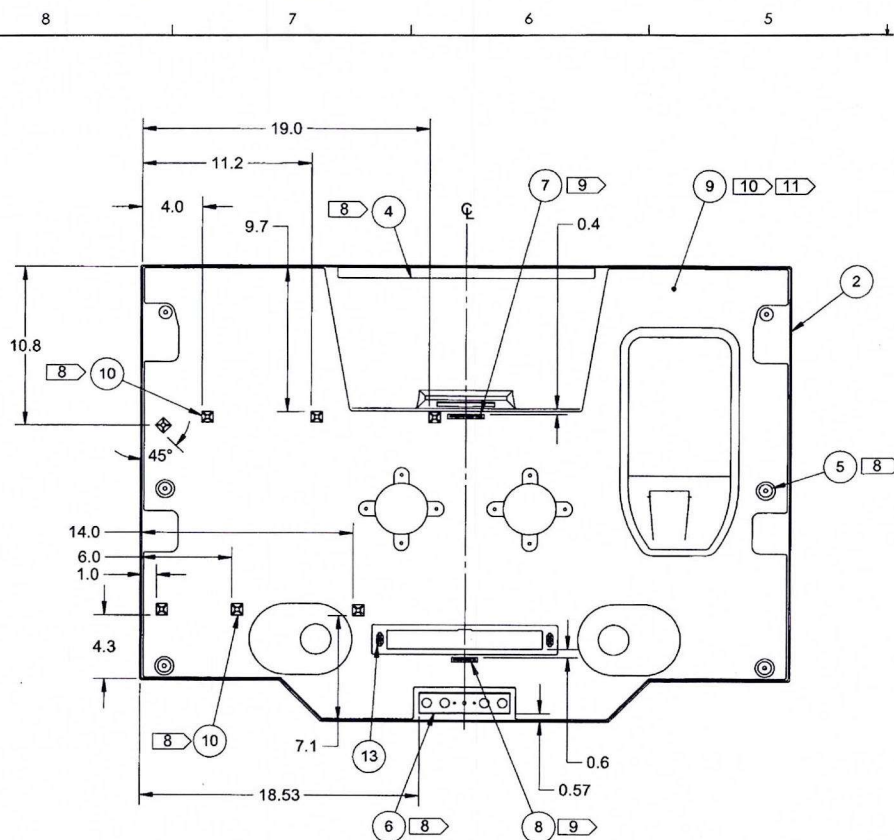
Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/15/18

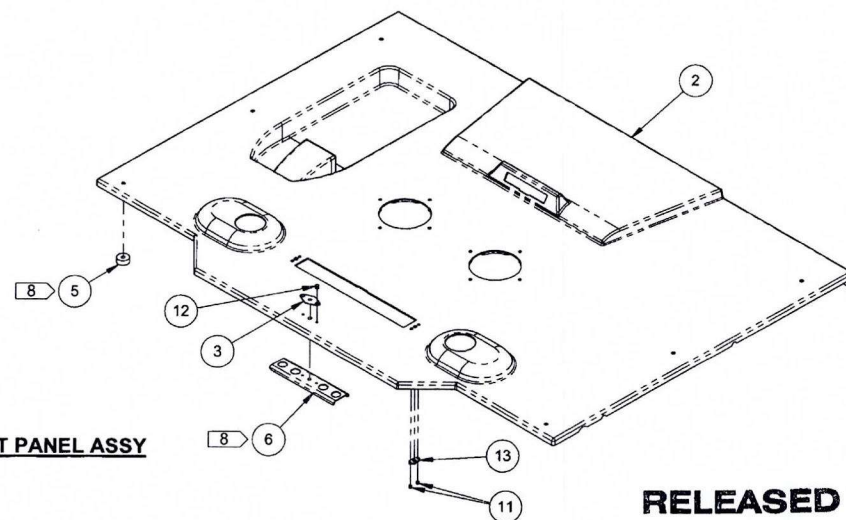


D4634-141 FWD, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4664-5, D4712-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-1 FOAM ON D4634-1

ITEM	QTY -141	P/N	DESCRIPTION
1	X	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-1	FWD, CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-5	DOUBLER
5	6	D4664-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-15	LABEL
8	1	D4732-19	LABEL
9	1	D5021-1	FOAM, CENTER PANEL, FWD
10	7	MPNY-750S-9-C	MOUNTING PAD
11	4	MS20426AD3-(4)	RIVET, SOLID, CSK
12	2	MS20426AD4-(6)	RIVET, SOLID, CSK
13	2	MS21059L08	NUT PLATE



RELEASED
2015 JAN 26 *qp*

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	AK	DRAWING NO.	REV. G
	MFG. APPR.	DL	D4634	SHEET 7 OF 17
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CENTER CEILING PANELS	NTS
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